SCHNEEBERGER

Dogbone 1-Sided Ø5

A8-105

The Dogbone Insert is ground with an easy dressable 300 mm in diameter 1A1 wheel. The wheel's periphery is always positioned tangential to the radius profile of the insert. The parts are clampled automatically in a specially designed dogbone holder an handled with our STL 650 loader. The loading cylce with the robot takes approximately 10 sec.
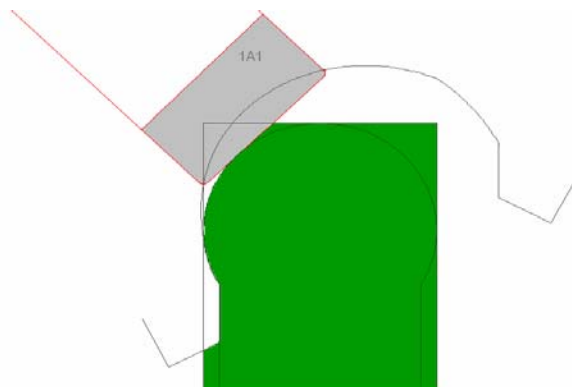

1. Cycletime for Production

Tool specifications Diameter 5 mm, Z 1, Length of cutting edge 5 mm Material HM			
Operations	Prof pregr	Prof fin.	probe dim.
Feed [mm/Min]	120	170	100
Power [kW]	1	1	1
Cutting feed [m/s]	24	24	24
Used wheels	1	1	
Grinding time [s]	25	20	17
Total cycle time	1 Min 1		

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1 Ø300 1A1 D46

1
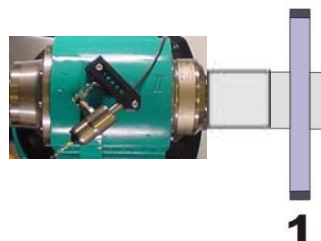
3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM, U-Insert Holder, STL 650
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 4.2, DXQ

responsible engineer: OP,4.4.07

TECHNOLOGY FOR TOOLING